

Work Order ID 76227

Monday, November 07, 2011 2:43:43 PM

\*76227\*

Page 1

Item ID: D3414-041

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Lug Assembly

Stop

\*NS2\*

Start Date: 11/7/2011 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 11/16/2011 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

*✓*

Date: 11/11/07

Tooling:

Date:

Run

Start

\*NR1\*

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3414	Rev C
-------	-------

100

\*100\*

Waterjet

FLOW CNC Waterjet

*344.100*

Memo

I-Cut as per Dwg D3414-1

Dwg Rev: *S*

Prog Rev: *S*

0.00

*111-11-21*

*33*

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Quality Control

Memo

0.00

*111-11-21*

*33*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

Sulul21

\*120\*

QC

Quality Control

130

\*130\*

Brake NC

Brake NC

Memo

0.00

0.00

Sulul22

23

140

\*140\*

Large Fab

Large Fab

Memo

0.00

0.00

1- Weld using location Jig DT9625 as per Dwg D3414  
A/R S.S. welding rod Batch: 1117653

11-11-23

23

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

**\*150\***

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

6/11/11-23

23x

160

**\*160\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Wu 123

center

+23

170

**\*170\***

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:00 0.00  
400 0F  
10:30

23 X 5 M/F 11/11/24

WV184361

W/O:		WORK ORDER CHANGES					
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Date:

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Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC3- Inspect Part Finish

0.00

\*180\*

QC

Quality Control

23 Bl 11-24.

190

Identify as per dwg & Stock Location: 55479. 0.00

\*190\*

Packaging

Packaging

0.00

23

Sp11-11-29.

200

QC21- Final Inspection - Work Order Release

0.00

\*200\*

QC

Quality Control

0.00

11/11/28

MF  
11-11-28

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Picklist Print**

Page 1

Monday, November 07, 2011 2:43:47 PM

Work Order ID: 76227

**\*76227\***

Parent Item: D3414-041

**\*D3414-041\***

Parent Item Name: Lug Assembly

Start Date: 11/7/2011

Required Date: 11/16/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S12GA		Purchased		No		100	sf	135.0800	0.155	3.1		3.5	
<b>*M304S12GA*</b> 304/316 0.100" Sheet									**			11-11-2	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT019	135.08	
113062	117.1	
113077	17.98	

D3414-3	Manufactured	No		140	Each	4.0000	1	20	**			
<b>*D3414-3*</b> Lug										11-11-23		

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
WA030	4	
72327	4	

75050 x 19.

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	76227
Description: Lug Bracket	Part Number:	D3414-1
Inspection Dwg: D3414      Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      X Prototype

Measured by: B	Audited by: S	Prototype Approval: N/A
Date: 11-11-21	Date: 11/11/21	Date: N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue P/O D3414-041	KJ/DD	
B	09.05.27	Dimensions updated per Dwg Rev B	KJ	
C	09.10.16	Dwg Rev updated to Rev C	KJ	 

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

D

D

C

C

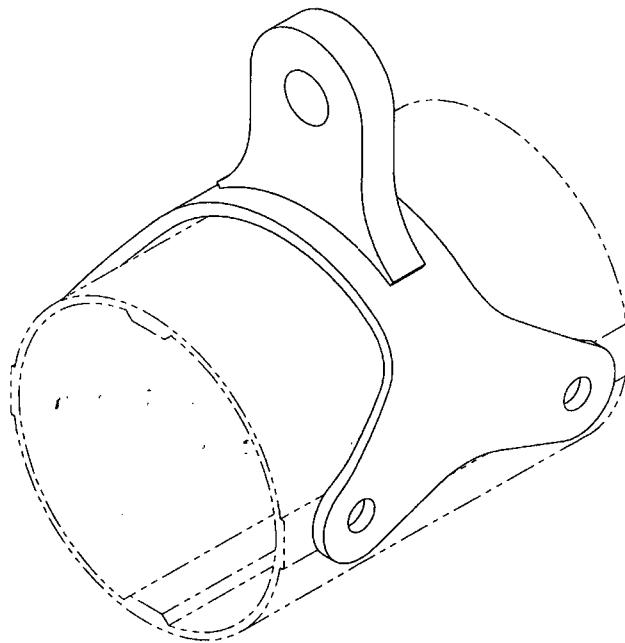
B

B

A

A

ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



**D3414-041 LUG ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *76227*

*11-11-07*

**RELEASED**  
*5/16/06 M*

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN A7-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR18). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP	DRAWING NO. <i>D3414</i> REV. C	
CHECKED		SHEET 1 OF 3	
MFG. APPR.		TITLE <i>LUG ASSEMBLY</i> SCALE <i>NTS</i>	
APPROVED	<i>WJ</i>	DE APPR. <i>SH</i>	
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS NOT TO BE COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

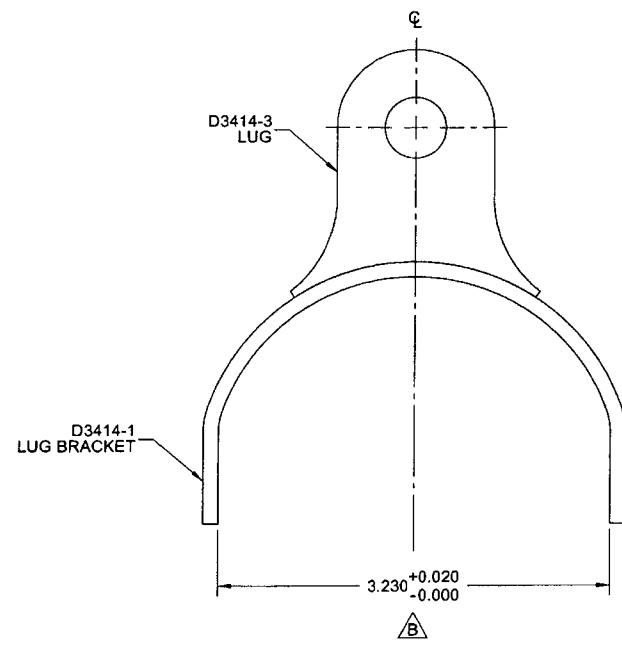
C

B

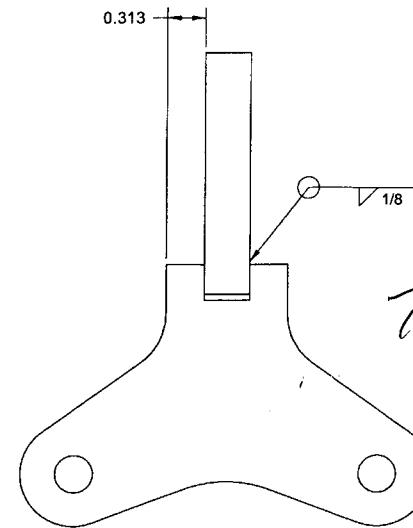
B

A

A



D3414-041 LUG ASSEMBLY



RELEASED  
09/16/06 AM

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. REV. C	
MFG. APPR.		D3414 SHEET 2 OF 3	
APPROVED		TITLE SCALE	
DE APPR.		LUG ASSEMBLY NTS	
DATE	09.06.17	COPRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS UNDER NO CIRCUMSTANCES TO BE COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

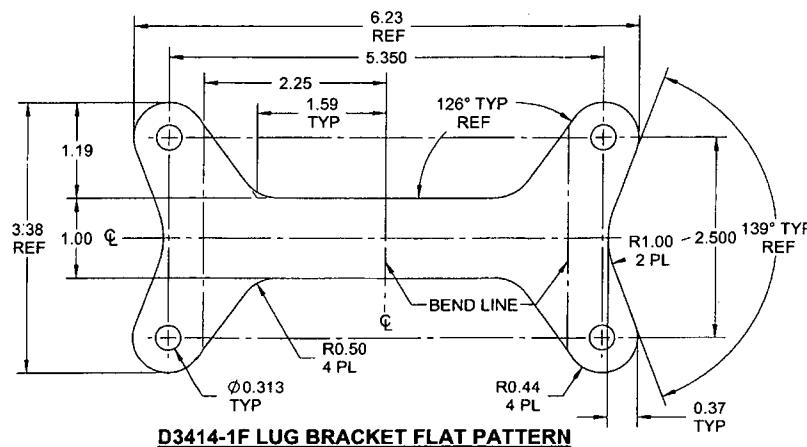
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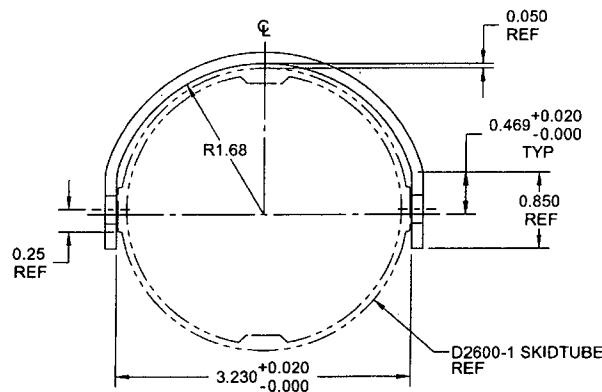
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## **D3414-1F LUG BRACKET FLAT PATTERN**



**D3414-1 LUG BRACKET**

**NOTES:**

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S12GA

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

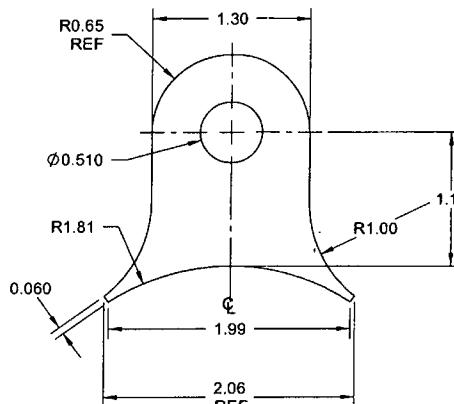
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX        
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

SIDE VIEW FOR REF ONLY



D3414-3 LUC

76227

RELEASED  
by *Castos* *MM*

DESIGN	CP	<b>DART AEROSPACE LTD</b>	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	✓	DRAWING NO.	REV. C
MFG. APPR.	✓	D3414	SHEET 3 OF 3
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	<b>LUG ASSEMBLY</b>	
DATE	09.06.17	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	

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